

Date: Tuesday, 4/17/2007 3:56:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT
Job Number	: 31921		
Estimate Number	: 11104		
P.O. Number	: <i>N/A</i>	Part Number	: D2364
This Issue	: 4/17/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2364 REV.F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 27737	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/2/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.6792 sf(s)/Unit Total : 6.7925 sf(s)

2024-T3 .063 Aluminum sheet

(M2024T3S063)

Batch: *M102942 8**M101022 (3)**11*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2364

Dwg Rev: *E*Prog Rev: *F*

2-Deburr if necessary

SAD 07/05/18
MF 07-05-23

11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/18**11*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/05/23 *(11)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FD**07/03/23**(11)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 31921

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

JS 07-05-28 (11)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/5/28 (11)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 226

PC 7/5/28 (11)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(11)

Comment: FINAL INSPECTION/W/O RELEASE

PC 07/05/28

Job Completion



U 07-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31921
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.628	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.173	✓		Vern	
0.354	+/-0.010	0.354	✓		Vern	
11.242	+/-0.010	11.250	✓		Vern	
3.031	+/-0.010	3.039	✓		Vern	
1.903	+/-0.010	1.909	✓		Vern	
1.128	+/-0.010	1.131	✓		Vern	
0.354	+/-0.010	0.355	✓		Vern	
1.340	+/-0.005	1.345	✓		Vern	
2.326	+/-0.010	2.330	✓		Vern	
3.312	+/-0.010	3.316	✓		Vern	
4.298	+/-0.010	4.298	✓		height gauge	
5.284	+/-0.010	5.283	✓		height gauge	
6.151	+/-0.010	6.153	✓		height gauge	
6.270	+/-0.010	6.268	✓		height gauge	
0.354	+/-0.010	0.353	✓		Vern	
3.031	+/-0.010	3.034	✓		height gauge	
Ø0.656	+0.005/-0.000	Ø0.656	✓		Vern	
5.003	+/-0.010	5.007	✓		height gauge	
4.605	+/-0.010	4.609	✓		height gauge	
1.776	+/-0.010	1.779	✓		height gauge	
0.980	+/-0.010	0.982	✓		height gauge	
4.487	+/-0.010	4.490	✓		height gauge	
7.192	+/-0.010	7.187	✓		height gauge	
7.567	+/-0.010	7.561	✓		height gauge	
7.942	+/-0.010	7.937	✓		height gauge	
Ø0.191	+0.005/-0.000	Ø0.191	✓		Vern	
Ø0.197	+0.005/-0.000	Ø0.199	✓		Vern	
11.145	+/-0.010	11.152	✓		height gauge	
12.181	+/-0.010	12.190	✓		height gauge	
11.378	+/-0.010	11.375	✓		height gauge	
11.776	+/-0.010	11.780	✓		height gauge	
12.173	+/-0.010	12.177	✓		height gauge	
4.690	+/-0.010	4.692	✓		height gauge	
0.250	+0.005/-0.000	0.249	✓		Vern	
3.141	+/-0.010	3.146	✓		height gauge	
0.1710, 128	+0.005/-0.000	0.130	✓		Vern	

Measured by:	SAD	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/05/18	Date:	Dec-23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	[Signature]



RELEASED
98/06/22 KG

NO. 31921